

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023344**Date Inspected:** 15-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

3AW and 3BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron Brace at Counter Weight for Segment 3AW to 3BW between PP 19 to PP 23. Inspected 10% of bolt final tensioning found satisfactory. Bolt sizes used are M22-2.5x70 RC Lot No. DHGM220020 and final Torque required is 520 N-m; Bolt sizes used are M22-2.5x75 RC Lot No. DHGM220005 and DHGM220034 and final Torque required is 473 N-m and 453 N-m, but all the bolts torque verification carried out at 473 N-m. Manual Torque wrench is been used with Sr. No. X02-584. The Inspection was scheduled from 0810 Hrs.

3AW and 3BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Floor Beam to I- Beam for Segment 3AW to 3BW between PP 19 to PP 23. Inspected 10% of bolt final tensioning found satisfactory for Counter weight and Cross Beam side. Bolt sizes used are M22 x 80 RC Lot No. DHGM220012 and

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DHGM220050 final Torque required are 427 N-m and 486 N-m, but all the bolts torque verification carried out at 486 N-m. Manual Torque wrench is been used with Sr. No. X02-584. The Inspection was scheduled from 1000 Hrs.

3AW and 3BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Side Panel Splice plate for 3AW to 3BW from PP 19 to PP 23 cross beam side. Inspected 10% found satisfactory. Bolt sizes used are M22x 2.5 x 65 RC Lot No. DHGM220021 and final Torque required is 543 N-m. The Inspection was scheduled from 1330 Hrs. 4AW and 4BW+ 3AW and 3BW

This Quality Assurance (QA) Inspector signed off the green tag document for 4AW to 4BW and 3AW and 3BW.

- 1.U-Rib to U-Rib for 4AW+ 4BW PP 24 and 25 Green Tag No. 43
- 2.Lower Chevron Brace (North and South) for 4AW and 4BW – PP24-28 Green Tag No. 44
- 3.Lower Chevron Brace (North and South) for 4AW and 4BW – PP24-28 Green Tag No. 45
- 4.FB to BP Clips for 3AW + 3BW – PP19-23 Green Tag No. 48
- 5.FB to BP Clips for 3AW + 3BW – PP19-23 Green Tag No. 49

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
